



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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15329

DAS
24
9-89

D5149-043W

Job Sheet 193254



Part No: D5149-043W

Job Qty: 6 pcs

Part Name: Aft Step Base Assembly Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15329

Due Date: 6/20/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV D SHEET 4 IPP REV:A 14.12.15 NEW ISSUE DD VERF;JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	6 pcs	6/20/19		0.00	5.17	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS 24 9-89	SEP 05 2019
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
120	QC 9	6 pcs	6/20/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43	DAS 43 9-89	
							QC 9 - 50		
130	QC 5	6 pcs	6/20/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3	DAS 43 9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



Container No: S211885



Part: D5149-043W

Job No: 193254

Serial No/Batch: S211885

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 09/05/19

Plex 4/9/19 3:47 PM Dart.Macdonald.Dara

P.T.O.

				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	6/20/19	0.00 0.79	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	6 pcs	6/20/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
QC 7 - 68					
				SEP 09 2019	
				PK 19 9 10.	
				Plex 4/9/19 3:47 PM Dart.Macdonald.Dara	

SEP 09 2019

PK 19 9 10.

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160	Powdercoat - 1 White GI(A)- B4B	6 pcs	6/20/19	0.00 0.14	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	6 pcs	6/20/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
180	Handfinish - 3-1- WingWalk- B4B	6 pcs	6/20/19	0.00 0.79	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
190	QC 3	6 pcs	6/20/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
200	Packaging 3-1 - Stock - B4B	6 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

MI 93459
STADI 1 2:30 O.V.T. 3:00 FINISH 3:00

BA 19-9-10

BEBA-09-11

BEBA-09-11

SFP 12 2019
40
9-00

FRI 9-13-2019
Oscar

GA-TBD

DAS
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9-89

					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	1	6 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21 ✓
						QC 21 - SA - 70
						QC 21 - SA - 53

EA-TBD

Part Op 110 - Large Fab 2 (Weld per dwg A/R Aluminum rod Batch: 138872)
 Descriptions: 120 - QC9 (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - QC5 (QC5- Inspect part completeness to step on W/O)
 140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 150 - QC7-4 (QC7-Inspect Chemical Conversion Coat)
 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)
 170 - QC3 (QC3- Inspect Part Finish)
 180 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch: 5209362)
 190 - QC3 (QC3- Inspect Part Finish)
 200 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 210 - QC21 (QC21- Final Inspection - Work Order Release)

DAS
21
9-19

SEP 13 2019

011766

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5149-5	Step Cap	6 pcs (1 ea)	110-Large Fab - Welded Assy-1	5209308
D5149-7	Aft Step Base	6 pcs (1 ea)	110-Large Fab - Welded Assy-1	5182586
D5149-9	Aft Step	6 pcs (1 ea)	110-Large Fab - Welded Assy-1	5182338

6 SCRAP

Good
BATCH

5182338

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D5149-5	6	14	0
	D5149-7	6	9	0
	D5149-9	6	8	0

Part Specifications

Specifications could not be found.

Entered: JK Date: Oct 25/9



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7579

Route update only

Job: <u>1932SA</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☒ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date : SEP 09 2019	Sequence #:		QTY Affected : 5/6			MRB (QS1042) DAS 51 19/09/09 9-89			
Description Work Order Deviation - PART CRACKED DURING WELDING.			Disposition - SCRAP / Destroy			Completed By DAS 24 SEP 09 2019 9-89			
						Lead hand / Supervisor DAS 24 SEP 09 2019 9-89			
						QC / QA Coordinator DAS 68 SEP 09 2019 9-89			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ ☒ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐						
			Other/Details:						